We ~~Claims~~ Claim

1. Process for the fashioning of a portion (3) of a profiled bead (2) extruded onto an object, in particular a pane (1), in which process an initially shapeless mass (4) of material is produced in the portion (3) in question and is given the desired final shape by contact with a shaped surface of a moving tool (5), any excess material being automatically expelled from the tool in order to be removed, **characterized in that** the mass (4) of material is produced by the superposition of two segments (2a, 2b) of the extruded strip, with the following steps:

- the extrusion die (D) is guided along a first segment (2a) of the intended path of the profiled bead (2), including the portion (3) to be fashioned;
- the die (D) is taken away from the object (1) and is moved, relative to the object (1), to an adjacent position of the portion (3) to be fashioned;
- the die (D) is guided again, along a second segment (2b) of the path of the profiled bead (2), also including the portion (3) to be fashioned.

2. Process according to Claim 1 for the fashioning of a corner (3) in the profiled bead (2), especially in a corner of the object, **characterized in that** the die (D) is moved relative to the object (1) by changing the relative orientation of the die (D) with respect to the object (1), especially by rotation through the desired angle, **and in that** the die (D) is guided in the new direction thus obtained.

3. Process according to Claim 2, **characterized in that** the first (2a) and/or second (2b) segment extend/extends beyond the perimeter of the object (1) so that the fashioned portion (3) projects beyond the end face of the object (1).

4. Process according to any one of the preceding claims, **characterized in that**, after the first segment (2a) has been extruded, the die (D) is moved by passing

it over that region of the first segment (2a) which includes the portion (3) to be fashioned.

5. Process according to any one of the preceding claims, **characterized in that** the extrudable material continues to be delivered by the die (D) while the latter is being moved.

6. Process according to any one of the preceding claims, **characterized in that** the moving tool (5) is applied against the portion (3) to be fashioned just after the die (D) has left that region of the second segment (2b) which includes this portion, in the actual extrusion station (E), without the object (1) being moved, transferred or repositioned.

7. Process according to Claim 6, **characterized in that** the moving tool (5) is automatically brought from a rest position to its working position immediately after the mass has been extruded and the extrusion die (D) has continued its travel, is automatically aligned with the profiled bead (2) and is brought into contact with the shapeless mass (4) in order to fashion it.

8. Device for the fashioning of a portion of a profiled bead (2) extruded onto an object - in particular onto a pane (1) - fastened in a treatment station (E), in particular for implementing the process according to Claim 1, in which device a moving calibrated tool (5) may be brought into contact with the said strip portion, comprising an initially shapeless accumulation of material (4), and applies against the latter a shaped surface corresponding to the uniform profile of the profiled bead, and in which device means are provided for cutting and removing the excess material, **being characterized** by the fact that the tool (5) is connected in a locally adjustable manner to the treatment station (E) provided for laying down the profiled bead (2) and can be moved between a rest position and a working position in contact with the object (1) fastened in the treatment station (E), by means of an actuating device (8), and in that means

(10, 11, 17) are provided for the correct and automatic adjustment of the relative position between the tool (5) and the object (1).

9. Device according to Claim 6, **being characterized by** the fact that the means for adjusting the position comprise at least one laying face (17) to be applied against the object (1) and a bearing (10, 11) having a spherical movement allowing adjustment of the position parallel to one face of the object.

10. Device according to Claim 9, **being characterized by** the fact that the bearing having a spherical movement is formed by a ball (10) fastened to a support frame (7) of the tool (5) and by a recess (11) receiving the said ball (10) in the baseplate (12) of the tool (5), which baseplate is made adjustable in a base position with respect to the support frame (7) by springs (13).

11. Device according to Claim 9 or 10, **being characterized by** the fact that the tool (5) furthermore comprises a sealing rim (16) to be applied against a perimeter of the object.

12. Device according to Claim 11, **being characterized by** the fact that the sealing rim (16) and the laying face (17) are formed in a removable stop (15) fastened to the baseplate (12).

13. Device according to one of the previous device claims, **being characterized by** the fact that the tool (5) comprises a punch (20) which can be moved by means of a cylinder (21) and has a surface for forming the profiled bead (2).

14. Device according to Claim 13, **being characterized by** the fact that a forming gasket (23) is fastened to the punch (20), which gasket, when the punch (20) is applied against the object, comes into contact with the top side of the latter and with the profiled bead, and the thickness of which gasket corresponds to the height of the profiled bead fashioned.

15. Device according to one of the previous device claims, **being characterized by** the fact that the tool (5) includes a cutting edge (19) for cutting the excess material from the fashioned portion of the profiled bead (2).

16. Device according to one of the preceding device claims, **being characterized by** the fact that the support frame (7) of the tool (5) is adjustable with respect to the treatment station (E) for various shapes of objects.

17. Device according to device Claim 16, **being characterized by** the fact that the actuating device includes a driving means (8) connected to the support frame (7).

18. Article, especially a window, comprising an object (1) provided with a profiled bead (2) extruded onto the object (1) and having a fashioned portion (3), **characterized in that** the fashioned portion (3) consists of a continuous folded ribbon of extruded material, in which ribbon the contiguous surfaces of the fold or folds adhere to each other along a possibly pellicular interface, which ribbon is fashioned by contact with a shaped surface.

19. Article, especially a window, comprising an object, especially a pane (1), provided with a profiled bead (2) extruded onto the object (1) and having at least one corner portion (3), **characterized in that** at least one corner portion consists of the superposition of at least two partial beads (2a, 2b) which adhere to each other along a possibly pellicular interface, which superposed bead is fashioned by contact with a shaped surface.